Work Orde Wednesday, Augu													Page 1
Item ID: Revision ID:	D3278-1				Accept					Setup	Start		
Item Name:	Support										Stop		
Start Date: Required Date:	8/31/2011 9/16/2011	Start Qty: 40 Req'd Qty: 40				Cust Item II Customer:	D :						
Reference:								_	T		Stant		
Approvals:	Process Pla	n:CL	Date:	1108/31	Tooling:	Da	te:		t		Start		
	QC:		Date:	·	SPC (Y/N):	Da	te:				Stop		
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr											
D3278	Rev	С											
Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut bla	ınk: 2.00" x 1.0	0" x 2.550" long	0.00	Luloa/2:	7		40	<u> </u>			
110 HAAS 1		HAAS CNC VERT			0.00								
HAAS CNC vertical	machine #1	Tumble QC2- Inspect parts	obveniny as b	3270 1	0.00	nd SL 11-09-6	29		(O)				
QC		Memo			0.00	- 11-09-29			40		Ø		

Quality Control

		WO	RK ORDER CHANG	ES					
STEP	PRO	OCEDURE CHAN	IGE	Ву	. 1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
				:				: 	
):	PAR #:			NCR: Y	es No	o DQA:		Date: _	
Re	esolution:	Disposition	:	_ QA: N/C	Clos	ed:		Date: _	
		WORK ORDE	R NON-CONFORMA	ANCE (N	CR)				
OTED	Description of NC		Corrective Action Section			Verifica	tion	Annroyal	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig	n & ate			Chief Eng	QC Inspector
							İ		·
					·				
		PAR #:	PAR #: Fault Categon Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Ye Resolution: Disposition: QA: N/C WORK ORDER NON-CONFORMANCE (New York Orde	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Note	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #:Fault Category:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Verification Section C Section C Chief Eng Chi

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73412

Wednesday, August 31, 2011 3:07:06 PM



Page 2

Item ID:

D3278-1

Accept

Setup Start

Revision ID:

Start Date:

Item Name: Support

Required Date: 9/16/2011

8/31/2011

Start Qty: 40.00 Reg'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Date:

Start

Stop

Stop



OC:

SPC (Y/N): Date:

Tool ID

Tool # Plan

Code

Accept

Qty

Reject **Qty**

Reject Number Stamp

Insp.

Sequence ID/ **Work Center ID**

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Memo

Run Hours 0.00

0.00

Set Up/

onl 1/09/30

Run

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

40 Bl 11-9-30.

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

0.00

□OVEN TEMPERATURE:

40X8 M/11/14/03

M118439

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·							,
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:		Date:	
	R	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	·
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR	R)	ļ		-
DATE	STEP	Description of NC			ion B	Verifica	tion	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
						-			
							ļ		
		·							

NOTE: Date & initial all entries

Work Order ID 73412

Wednesday, August 31, 2011 3:07:06 PM



Page 3

Item ID:

D3278-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Support Item Name:

Required Date: 9/16/2011

8/31/2011

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Start Run



QC: _____ Date: ____

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

Run Hours

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty

Reject Number

Insp. Stamp

Qty

170

180

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

QC21- Final Inspection - Work Order Release

Quality Control

Memo

0.00

0.00

Duit Aci	ospace	Liu								
W/O:			W	ORK ORDER CHANG	ES			-		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					3					
							·			
Part No	•	PAR #:	Fault Cat	egory:	_ NC	R: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	_ QA	NC C	losed:		Date: _	•
NCR:			WORK OR	DER NON-CONFORMA	ANCE	(NCI	R)	:		
DATE	STEP	Description of NC		Corrective Action Section	ion B		Verific	ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign Date	& Secti		Chief Eng	QC Inspector
							,			
					·			, ,		
		·								
										

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 3:07:04 PM

Work Order ID: 73412

Parent Item:

D3278-1

Parent Item Name: Support



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: □A□04.04.19□New issue□KJ/JLM□

B 07.09.06

rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00		Purchased	No		100	f	47.0890	0.2337	9.84			



6061-T6 Bar 1.00 x 2.00

Location	Loc Qty	Loc Code
MAT004	47.089	
112567	22.6	
116623	3.36	
118106	21.129	

M119007 × 9.84

Dail Ac	Ospaci									
W/O:				WORK ORDER	CHANGES					
DATE	STEP		PR	OCEDURE CHANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									<u> </u> 	
									li i	
Part No	:		PAR #:	Fault Category:	NCR:	Yes	No DQ	A :	Date: _	
	R	Resolution:		Disposition:	QA: N	/C C	losed:		Date: _	
		1		WORK OPPED NON CON	ICODRANIOE /		<u> </u>			

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)		-	
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
							·	
					ļ			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	734/2
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	098			vern JL-3	
0.359	+/-0.005	359			1	
0.609	+/-0.010	.615				
0.250	+/-0.010	,250	-/ •			
1.480	+/-0.005	1.480				
R0.125	+/-0.010	-125			Rus	
0.119	+0.005/-0.004	124				
2.439	+/-0.010	2.439	/			
1.980	+/-0.010	1.980			į,	
R0.13	+/-0.030	. 13			2-6	
Ø0.257	+0.005/-0.000	-258				
R0.375	+/-0.010	345	/			
0.875	+/-0.010	,875				
0.500	+/-0.010	,501				
R0.400	+/-0.010	-400				
R1.00	+/-0.030	1-00				
	·				,	
1.720	+/-0.010	1.423				
R0.125	+/-0.010	-125				
0.125	+/-0.010	- /30	/			·

Measured by:	Audited by:	and	Prototype Approval:	N/A
Date: 1 -09-09	Date:	11/19/30	Date:	N/A

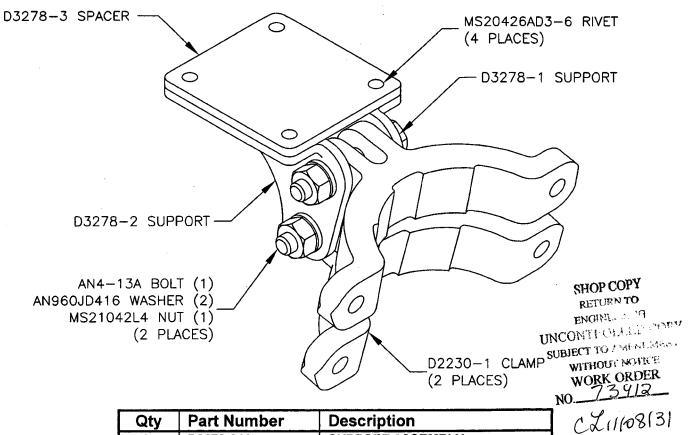
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
С	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	E



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	DESIGN DRAWN BY CHECKED APPROVED,		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
			APPROVED	DRAWING NO.	REV. C	
ĺ		-4	#	D3278 SHE	ET 1 OF 3	
	DATE			TITLE	SCALE	
	07.0	7.24		SUPPORT ASSEMBLY	NTS	
	Α	٠.	04.03.03	NEW ISSUE		
	В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT		
	_		07 07 24	CHANGED RIVETS PER PAR #185		



D3278-041 SUPPORT ASSEMBLY



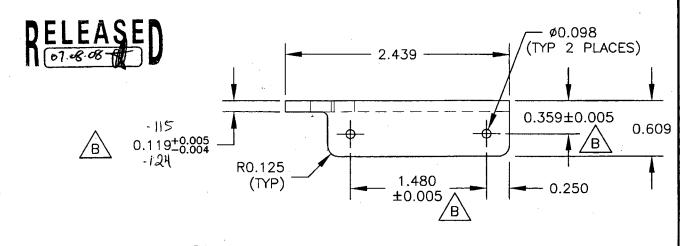
Qty	Part Number	Description	
Х	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

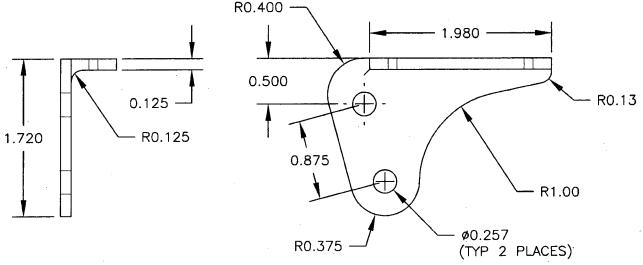
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CHECKED	APPROVED	DRAWING NO.		REV.	٠.
7,			SHEET		
DATE		TITLE		SCA	LE
07.07.24		SUPPORT	ASSEMBLY		1:1





D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

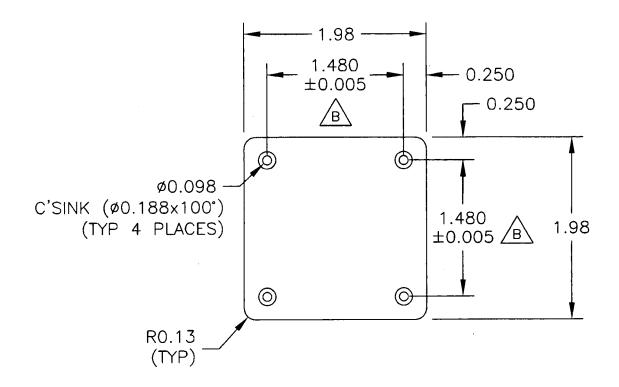
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CHECKED	APPROVED,	DRAWING NO.	REV. C
1 - P		D3278	SHEET 3 OF 3
DATE	•	TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

DELRIN II 150E OR ACETRON GP ACETAL (REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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